

SMALL FAS

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7-17
8-21

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEM633V3000102
Job Sheet 178181



Part No: RBEM633V3000102 Job Qty: 1 ea

Part Name: Main Gear Box Bar Pins Exchange



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 5/28/18

Job Tracking No:

Due Date: 7/16/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM633V3000102 Rev. 2 IPP Rev. A 18.05.15 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/16/18	7/16/18	0.00	0.00	Start Up Small Fab-4		MCL
110	Small Fab	1 pcs	7/16/18	7/16/18	0.00	0.10	Small Fab-6		MCL DAS
120	QC	1 pcs	7/16/18	7/16/18	0.00	0.00	QC5		DAS 38
130	Packaging	1 pcs	7/16/18	7/16/18	0.00	0.00	Packaging3-1		21 SEP 26 2018
140	QC21-FG	1 Ea	7/16/18	7/16/18	0.00	0.00	QC21		DAS

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver as per DWG 2-Transfer drill Dart placard RB41011 into Pelican case APP-1200E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case as per 1-100 placard RBEM633V3000102-1 to RBEM633V3000102-5 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	90-Start up Operation	5075949
APP-1200-E	Case	1 Ea (1 ea)	90-Start up Operation	5089370
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	5021040
RBEM633V3000102-1	Placard, Plastic	1 Ea (1 ea)	90-Start up Operation	5094756
RBEM633V3000102-3	Bottom Foam 2.93 X 7.23 X 9.41 (Ethafom 220, Black)	1 Ea (1 ea)	90-Start up Operation	5089372
RBEM633V3000102-5	Top Foam 1.19 X 7.19 X 9.37 (Ethafom 220, Black)	1 Ea (1 ea)	90-Start up Operation	5089373
RBEM633V3000124	MGB Bar Pin Exchange	1 Ea (1 ea)	90-Start up Operation	5113649
RBEM633V3000131	MGB Bar Pin Thimble	1 Ea (1 ea)	90-Start up Operation	5113658

140E
152F

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	4	219	0
	APP-1200-E	1	8	0
	RB41011	1	903	0
	RBEM633V3000102-1	1	0	0
	RBEM633V3000102-3	1	0	0
	RBEM633V3000102-5	1	0	0
	RBEM633V3000124	1	0	0
	RBEM633V3000131	1	0	0

17882
→ 13150

1807514

Part Specifications

Specifications could not be found.

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Container No: S113697



Part: RBEM633V3000102

Job No: 178181

Serial No/Batch: S113697

Revision: 2

Inspector:

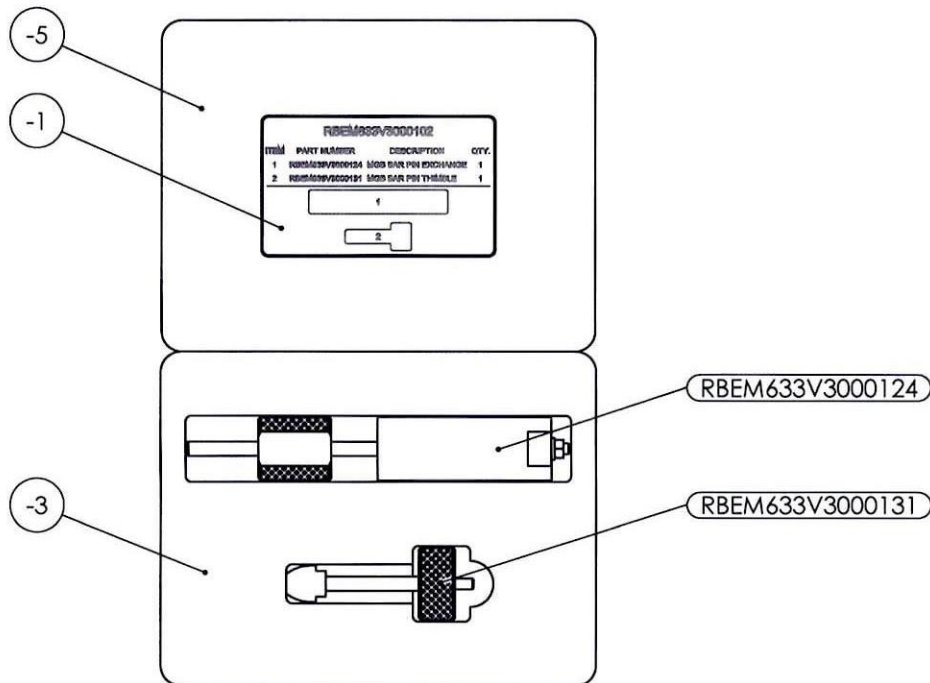
Exp Date:

Instructions:

Date: 09/26/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	6/17/2016	DPD	JAG
2	16-0134	-3 & -5 CH'D VENDOR & MATERIAL WAS Y20 BLACK, I.R. SPECIALTY IS ETHAFOAM 220, BLACK, CASE SOLUTIONS. -3 DELETED DIM 4X R.44, ADDED DIM'S 4X 45°, 4X .75, R.50, 2.20, CH'D DIM WAS 6.69 IS 3X 6.69. -5 DELETED DIM 4X R.44, ADDED DIM'S 4X 45°, 4X .65.	11/9/2016	RJC	SM



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WORK ORDER
NO. 178181
20180712
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NOTE:
REF. AIRBUS T/N: M633V3000102.

DART AEROSPACE																									
TITLE MGB BAR PIN EXCHANGE																									
DWG NO. RBEM633V3000102	REV 2																								
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td></td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES = 125</td> </tr> <tr> <td>SPEC</td> <td>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td>DRAWN BY: DUERFELDT</td> <td>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td>CHECKED: CLOUGH</td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td>OPPS APPR: ANDERSON</td> <td></td> </tr> <tr> <td>QA APPR: LINDSAY</td> <td>USED ON MODEL</td> </tr> <tr> <td>APPROVED: GILBERT</td> <td>H175</td> </tr> <tr> <td>SCALE 1:4</td> <td>DATE 3/28/2016 SHEET 1 OF 4</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	TREAT	DIMENSIONS ARE IN INCHES	FINISH	.XXX ± .005 FRACTIONS ± 1/8		.XX ± .01 ANGLES ± 5°		.X ± .1 SURFACES = 125	SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	OPPS APPR: ANDERSON		QA APPR: LINDSAY	USED ON MODEL	APPROVED: GILBERT	H175	SCALE 1:4	DATE 3/28/2016 SHEET 1 OF 4
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SCALE 1:4	DATE 3/28/2016 SHEET 1 OF 4																								

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	MGB BAR PIN EXCHANGE		RBEM633V3000124	1
				1	MGB BAR PIN THIMBLE		RBEM633V3000131	1
			-1	1	PLACARD	PLASTIC		2
		B/O	-3	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	2.93 X 7.23 X 9.41 (CASE SOLUTIONS)	3
		B/O	-5	1	TOP FOAM	ETHAFOAM 220, BLACK	1.19 X 7.19 X 9.37 (CASE SOLUTIONS)	4
		B/O	-7	1	CASE	PLASTIC	PELICAN #APP-1200-E	N/S
		B/O		1	PLACARD	ALUMINUM	RB41011	N/S